

Date: / Wednesday, 6/27/2007 1:08:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 33217		
Estimate Number	: 10618		
P.O. Number	: <i>N/A</i>	Part Number	: D265637
This Issue	: 6/27/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: D
Previous Run	: 32017	Material	: <i>N/A</i>
Written By	:	Due Date	: 7/19/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: D 02.10.25 Re-format KJ Est Rev: F 06-06-12 Now on Waterjet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.5650 sf(s)/Unit Total : 11.3001 sf(s)
 1010/1025 .040" SHEET
 (M1010S20GA)
 Batch: *M104921*

HB 07-07-27

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: *D*
 Prog Rev: *D*

HB 07-07-27

2-Deburr if necessary

*SAD 07/07/30**(22)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-07-27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/07/30 (22)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

*SAD 07/07/30**(22)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/08/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33217

Part Number: D265637

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



(PR3)

Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326.

2- Identify as D2656-37

FF 07-08-07 22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EN 07/08/08 (X22) counted

8.0

POWDER COATING

POWDER COATING



M104846



(22X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 07/08/09

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-15

BR

07-08-10

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(22)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/10

Job Completion



CY 07/08/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

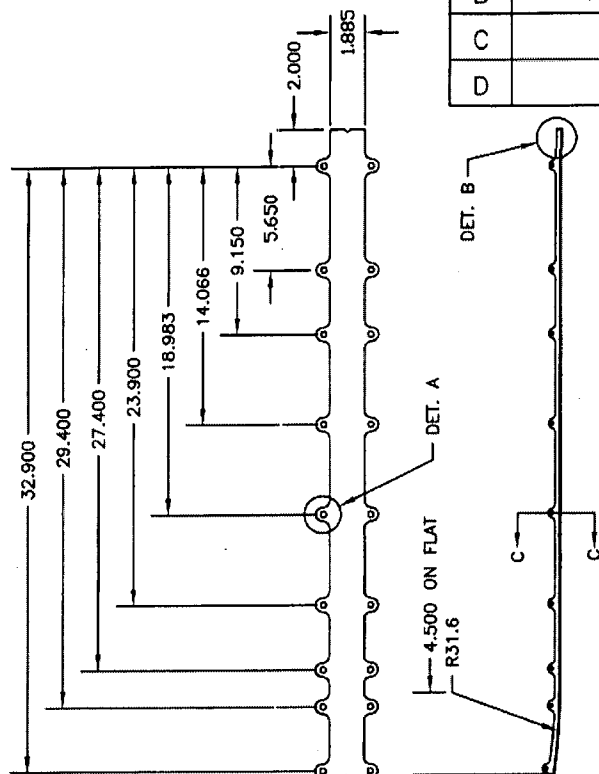
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-07	6.0	All parts scrap. Parts were not bent correctly & Angle bend was not made before forming the round. Also due to a pointy piece of material in the bottom die & large gouge marks were on all the legs. Root Cause: Human error, and improper bend process.	J	Scrap - destroyed Qty 22 parts. - Replace 2 step, 1.0. wrong W/O 07-08-07			J	J

NOTE: Date & initial all entries

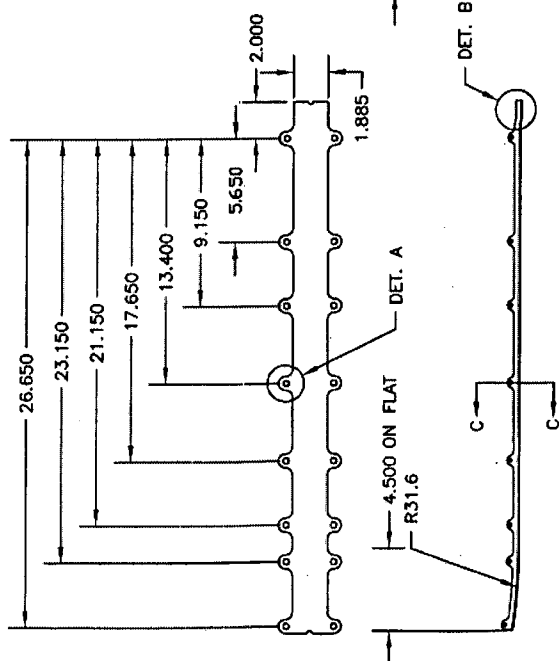


DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

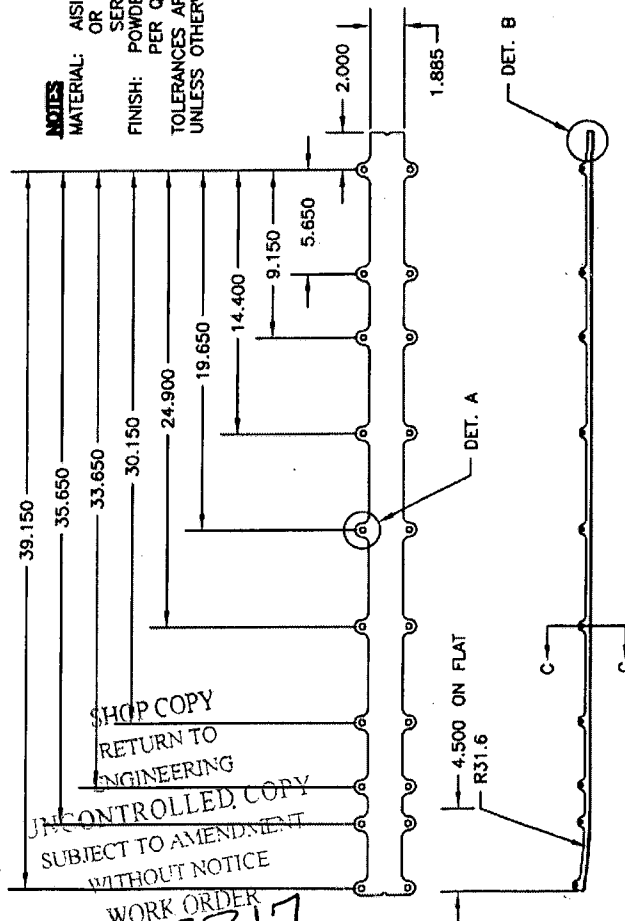
D2656-13



D2656-11



D2656-15



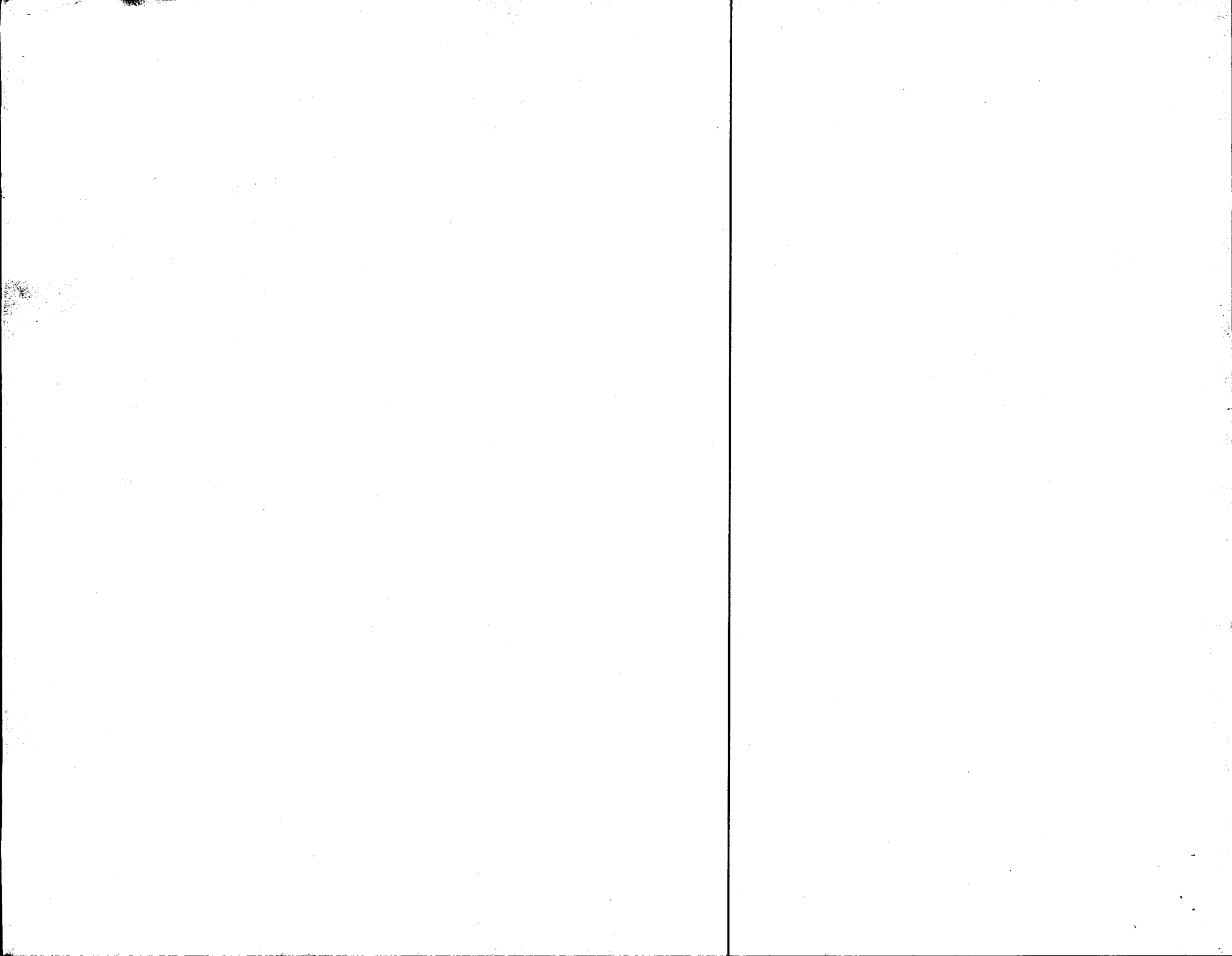
NOTES
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
 OR CSA C40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
 PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
 UNLESS OTHERWISE NOTED

RELEASED
 05-09-08

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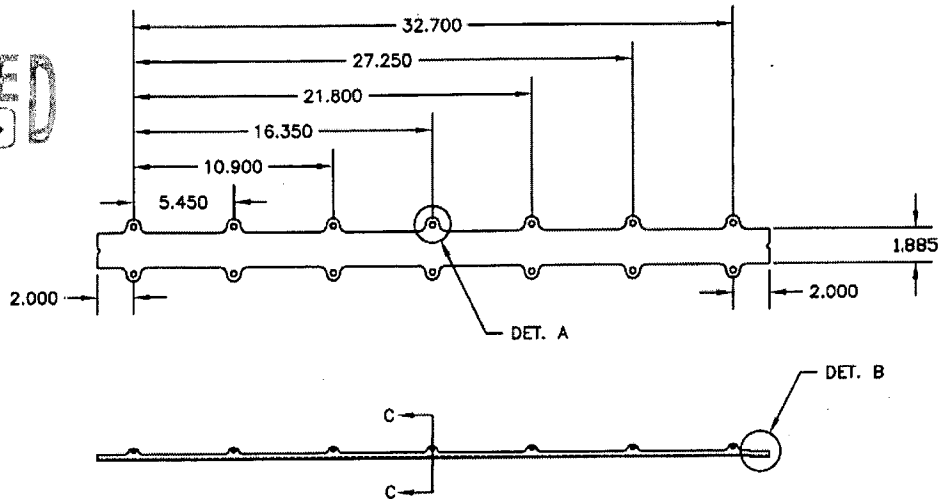




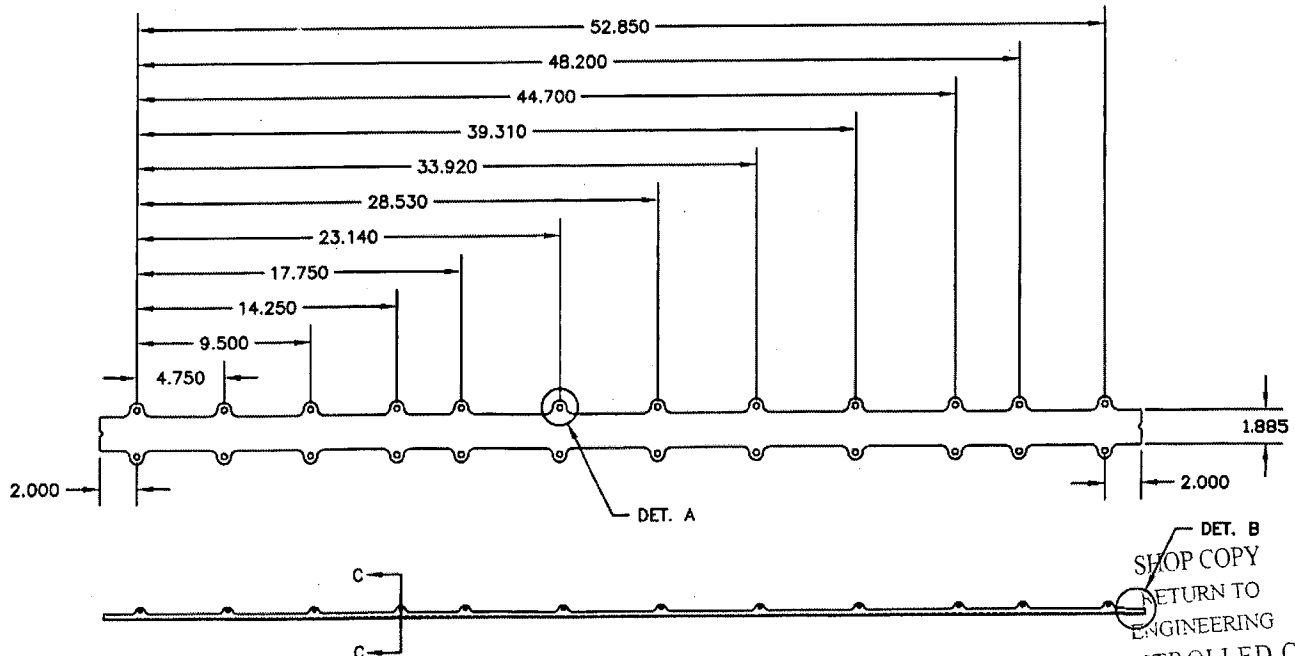
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DATE	05.08.17	TITLE	WEARSHOE	REV. D
				SHEET 2 OF 4
				SCALE 1:10

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DS 07.06 *[Signature]*

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
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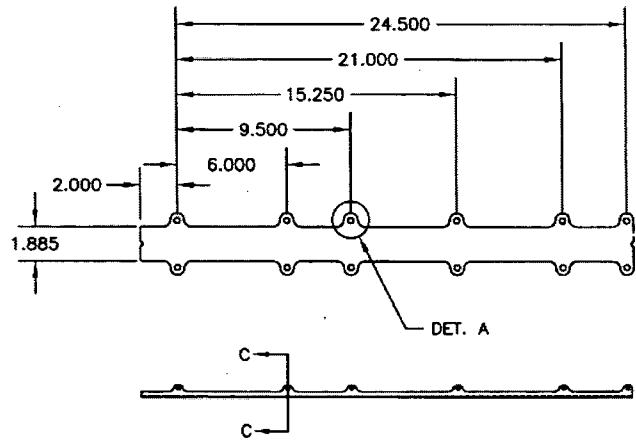
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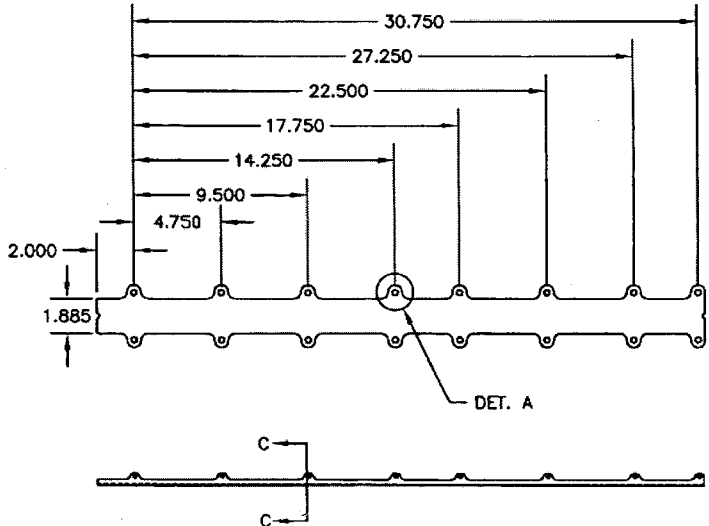


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		TITLE	WEARSHOE	SHEET 3 OF 4
				SCALE
				1:10

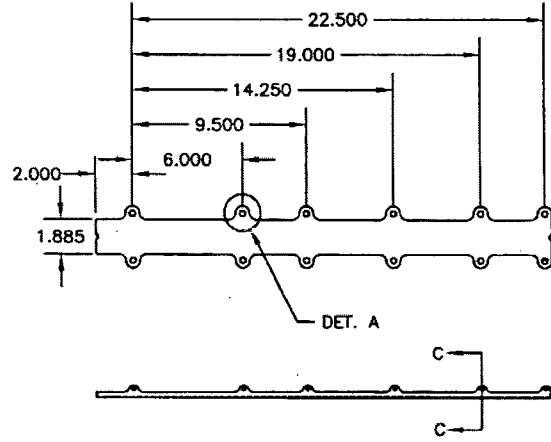
D2656-33



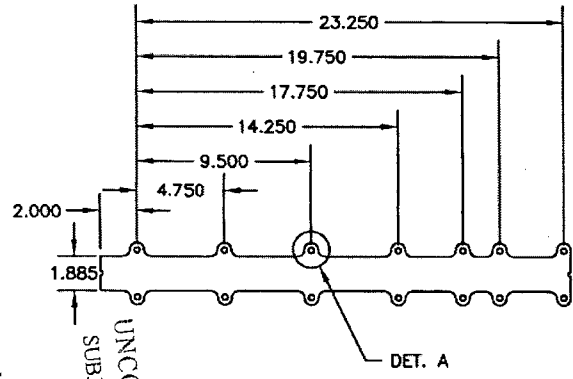
D2656-37



D2656-31



D2656-35



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SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

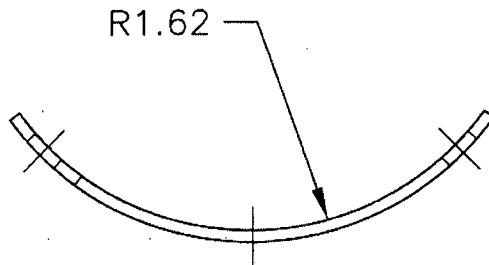
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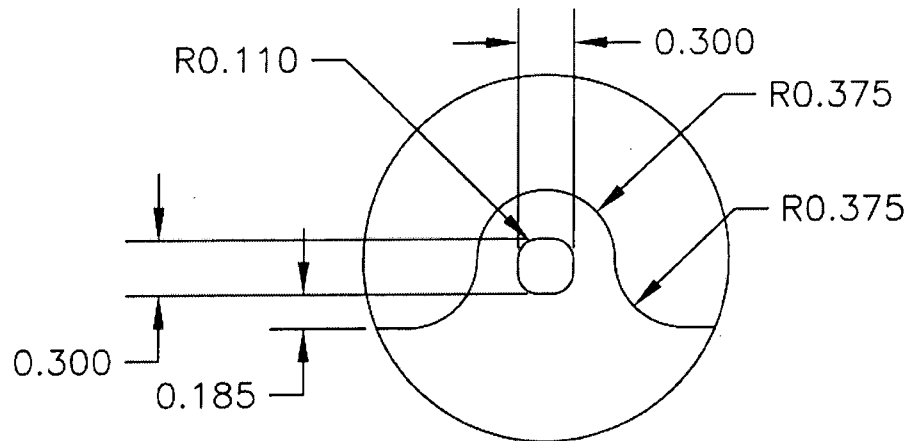
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

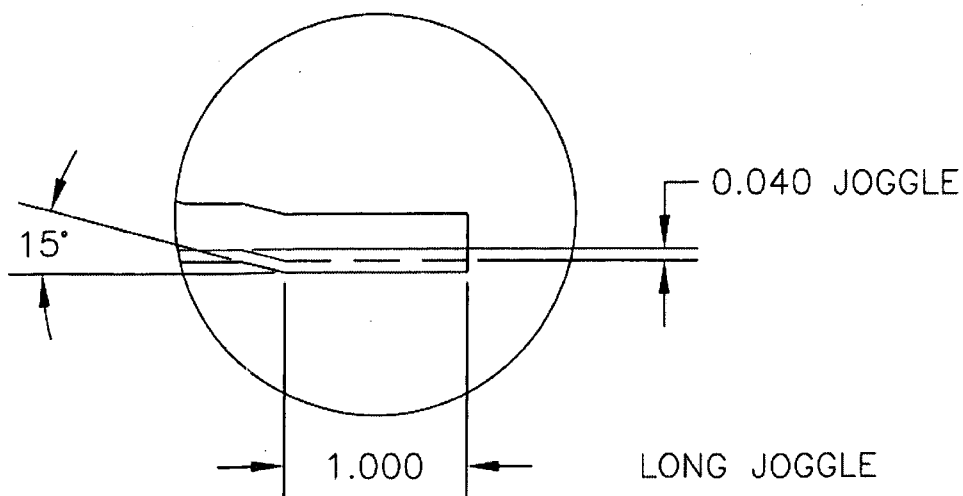


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05.09.06

DETAIL A



DETAIL B



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